

54740 D REV

Work Order ID 53677

November 12, 2009 8:32:11 AM



Item ID: D3602-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Angle

Start Date: 11/12/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3602

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3602 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ I2-
Deburr if necessary

HB 9-11-12

(15)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-11-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

15

15 11-13

Work Order ID 53677

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Item ID: D3602-1

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Item Name: Angle

Start Date: 11/12/09 Start Qty: 10.00

Required Date: 11/13/09 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Form as per Dwg D3602

0.00

0.00

8 09/12/08

15 0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Polish m-k 09/12/08

275 09/12/17

(15X) m-k 09/12/15

(15) 0

150



Packaging

Packaging

Identify as per dwg & Stock Location: 241A

Memo

0.00

0.00

9/12/17 1525

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Item ID: D3602-1

Accept



Setup Start



Revision ID: B

Item Name: Angle

Stop



Start Date: 11/12/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/18 HJ

Re 09-12-18
(15)

Picklist Print

November 12, 2009 8:32:10 AM

Page 1

Work Order ID: 53677

Parent Item: D3602-1RevB

Parent Item Name: Angle

Comments:

Start Date: 11/12/09

Required Date: 11/13/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	334.3871	6.1579	10.		



304/316 .040 Sheet



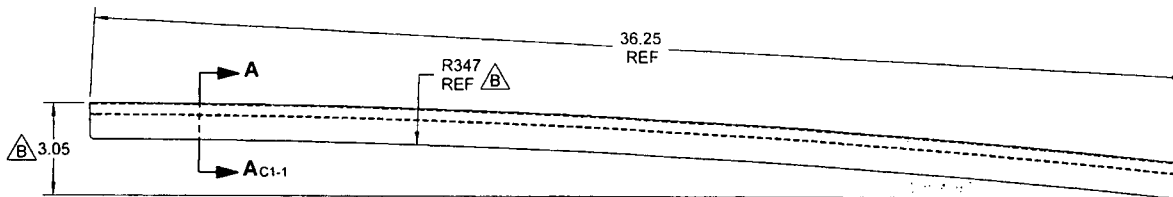
U39-11-12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	334.3871158	
110076	1.37053684	
111571	0.94	
112567	38.0765789	
112885	83.1578	
113062	185.8422	
113077	25	

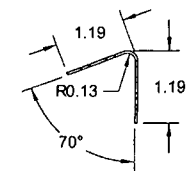
113062

⑤

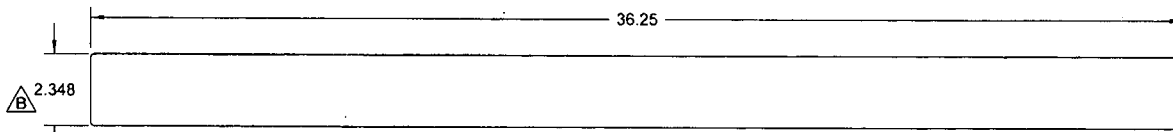
53677



D3602-1 ANGLE
(MAKE FROM D3602-1F)



SECTION A-A
SCALE 2X



D3602-1F FLAT PATTERN

R0.13
TYP

RELEASED
09/03/11

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.97 lbs

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3602** REV. B
TITLE **ANGLE** SCALE NTS

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